

Work Order ID 92538

92538

Page 1

October-31-12 11:41:53 AM

Item ID: 647.1401

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Upper Cutter Assembly

Stop

NS2

Start Date: 11/02/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-11-01

QC:

Date:

Tooling:

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

647.1400

N/C

110

Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

13-4-18

120

120

Small Fab

Small Fab

Memo

0.00

Assemble as per dwg and apply loctite 598 on all mating surfaces per note 2.

A/R LOCTITE 598: 125174

13-4-18

130

QC5- Inspect part completeness to step on W/O

0.00

DAS
16
8-01 13-04-19

130

QC

Quality Control

Memo

0.00

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>									
Root Cause Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector			
FAULT CATEGORY															
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio				Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions				Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	

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Page 2

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NS2

Start Date: 11/02/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

140

Identify as per dwg & Stock Location:

ST538

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Packaging

Packaging

Memo

0.00

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Quality Control

Memo

0.00

/x

SP

13-4-22

13/4/23 (J)

PLB 04/22

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

Date:

QA Closed: _____ Date: _____

Date:

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other						
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup														
Other														
Process														
Supplier														
Training														
Unapproved														
FAULT CATEGORY														
Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish Folio				Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration Out of Sequence Outside Dimensions			Ovalized Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	

Picklist Print

October-31-12 11:41:53 AM

Page 1

Work Order ID: 92538

Parent Item: 647.1401

Parent Item Name: Upper Cutter Assembly

Start Date: 11/02/12

Required Date: 11/16/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.10.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
646.9701 Cutter Sub Assembly		Manufactured	No		91805		Each	0.0000		1	1	RD	13-4-18
NAS1149FN832P Washer		Purchased	No				Each	923.0000		6			
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							275	198					
							122441	198					
							ST275	125					
							115158	125		6	6	RD	13-4-18
							ST294	600					
							123352	200					
							123522	400					
MS27039-08-19 Screw		Purchased	No				Each	700.0000		3			
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							ST307	124579			3	3	RD 13-4-18
							123525	100					
							ST308	600					
							123352	600					
MS21042L08 Nut		Purchased	No				Each	1,189.0000		3			
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							315	123900			3	3	RD 13-4-18
							122452	9					
							ST315	500					
							122814	500					
							ST317	680					
							122141	680					
647.1510 Upper Deflector		Manufactured	No		125082		Each	0.0000		1	1	RD	13-4-18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend	Grain	Ovalized	Pressure/Forced							
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure							
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld							
Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled							
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset									
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 02962					SHEET 1 OF 1	
	DWG NO. 647.1400		REV: N/C	PREPARED BY	R. ROSANO	DATE: 09/01/10	
	DWG TITLE: CUTTER ASSY						
	APPROVED BY:	ENGR <i>P. Brown</i>	MFG <i>Dawn Boh</i>	QC <i>Manu D. Lengen</i>	EFF: CURRENT ORDER		
	REASON: REPLACED CUTTER BODY IN 647.1401						
	TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE						

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK CRIME
 NO. 92538 MLJ

(2-11-01)

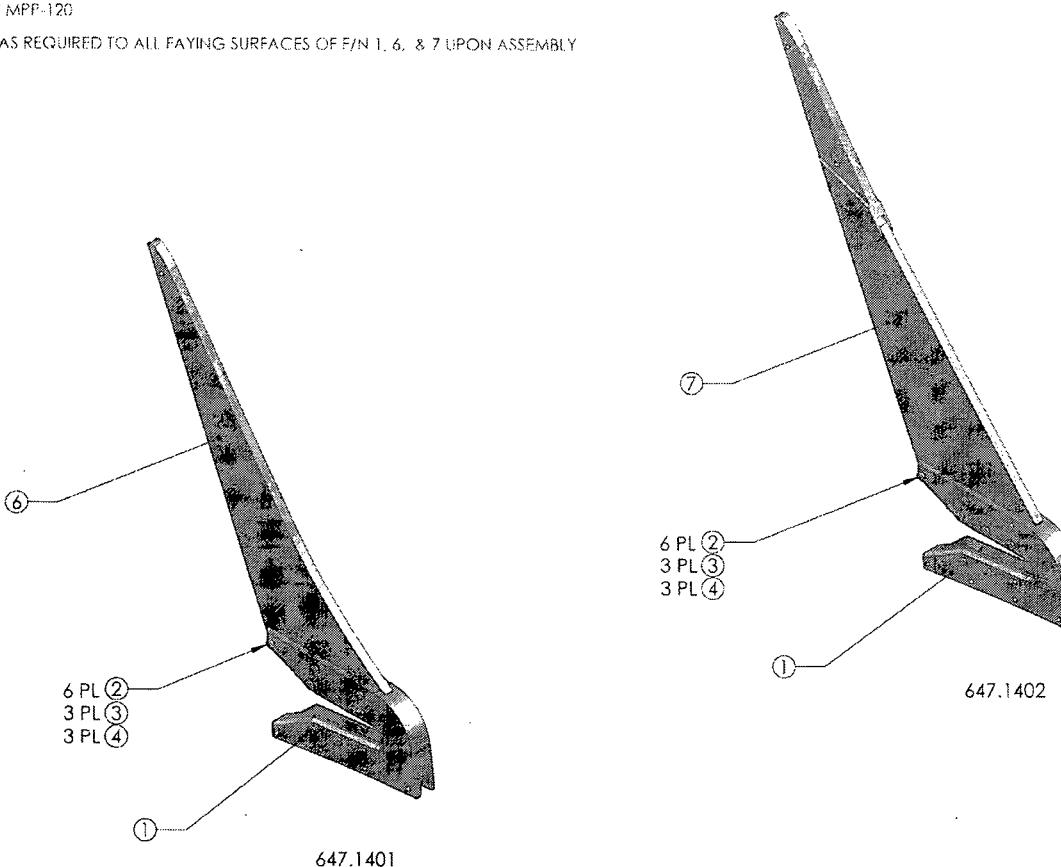
8	A	648.3601		1	CUTTER SUB ASSY		
1	R	646.9701	1		CUTTER SUB ASSY		
F/N	TC	PART NUMBER	1402.1401	QTY	DESCRIPTION		MATERIAL
DOCUMENTS EFFECTED:		□ MDL	□ INSTALL INSTRUC	□ ICA	□ BOM	CHANGE CATEGORY □ MAJOR <input checked="" type="checkbox"/> MINOR	DER REVIEW REQUIRED □ YES <input checked="" type="checkbox"/> NO

Category	Sub-Category	Quantity	Unit	Unit Price	Total Price
Electronics	Smartphones	10	Unit	500.00	5,000.00
Electronics	Laptops	5	Unit	800.00	4,000.00

NOTES:

1. IDENTIFY IAW MPP-120
2. APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 1, 6, & 7 UPON ASSEMBLY

92538



UNINCORPORATED ECN(s)

0390

	I	7	647.1501	LOWER DEFLECTOR ASSY	
	I	6	647.1510	UPPER DEFLECTOR	
A/R	A/R	5	601.2645	RTV, LOCTITE 598	
3	3	4	601.1541	NUT	MS21042L08
3	3	3	601.2765	SCREW	MS27039-0819
6	6	2	601.2764	WASHER	NAS1149FN832P
I	I	I	646.9701	CUTTER SUB ASSY	
X			647.1402	CUTTER ASSY (LOWER)	
	X		647.1401	CUTTER ASSY (UPPER)	
1402	1401	FIND #	PART #	DESCRIPTION	MATL
					SPEC

QTY	PARTS LIST		
NEXT ASSY (S)	OPTIONAL DATE 08/08/02	08/09	APICAL INDUSTRIES
647.1300	DRAWING NO.	CHICAGO	2608 TEMPLE HEIGHTS DR.
	10-0100	5 BRAVO	OCEANSIDE, CA. 92056-3512 (760) 724-5300
	PRINTING APPROVAL		
	REVISIONS		
	COMPLAINT		
	ITEMS CHANGED/REMOVED ITEMS ADDED/CHANGED FOR INFORMATION ONLY 1 PLACE DECIMALS 1000 2 PLACE DECIMALS 100 3 PLACE DECIMALS 10000		
	SUB	CAGE CODE	DMG 113
		B 071426	647.1400
	SCALE: NONE		
	SHEET 1 OF 1		